

(B)

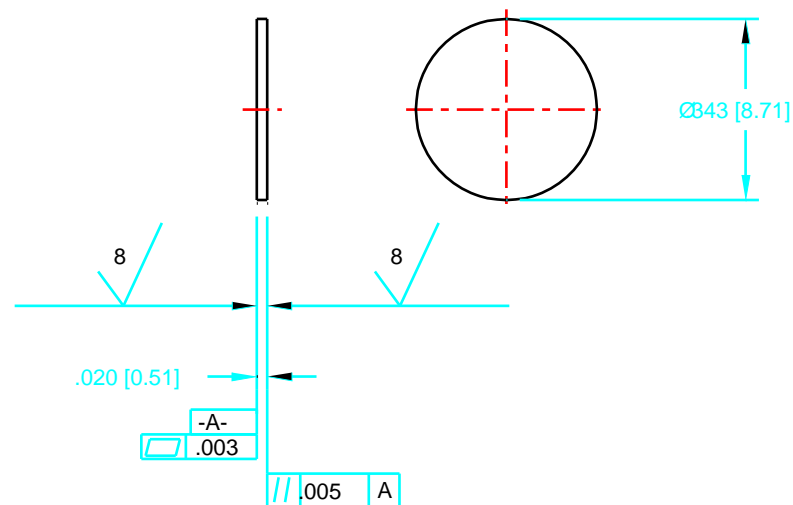
PLOT SCALE: 1=1

DWG. SCALE: 1

A247400

NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
 - A) CIMCOOL 5 STAR 49
 - B) TRIM SOL
3. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
4. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
5. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1×10^{-9} TORR CAN BE ACHIEVED
6. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
7. BREAK ALL SHARP CORNERS 0.03
8. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY



SCALE 4X

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION		MATERIAL / SPEC		QTY
PARTS LIST						
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A2471400		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
TOLERANCES DECIMALS ANGULAR .X - .03 [.7620] - .25 .XX - .01 [0.25] .XXX - .005 [0.127]		DRAWN BY MUSCIA		DATE 6/3/96	CHIEF DESIGN ENGINEER D. SHU	DATE 6/4/96
SURFACE ROUGHNESS 125 ✓		CHECKED BY D. SHU		DATE 6/4/96	GP LEADER T.M. KUZAY	DATE 6/6/96
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		DESIGNER SHU/MUSCIA		DATE 6/3/96	PROJECT MGR.	
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		RESPONSIBLE ENGINEER D. SHU		DATE 6/4/96	APPROVED/RELEASED	
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		MATERIAL BERYLLIUM		SCALE 1:1	SIZE B	DRAWING NUMBER P4105090801-820002-00
DO NOT SCALE DRAWING				SHEET 1 of 1		

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				